

010903



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1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**D4038-043**  
**Job Sheet 196418**



Part No: D4038-043

Job Qty: 2 pcs

Part Name: Angle Assembly Aft LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

**Note:** DWG D4038 REV.F SHEET 2 IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP Rev:B 11.01.31 as per dwg rev.c DD verified by:ec IPP REV:C 18.02.08 DWG REV.F DD VERF:DP

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                      | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-------|--------------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|       |                                |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 110   | Small Fab - 1                  | 2 pcs | 7/12/19    |          | 0.00      | 0.50    | Small Fab - 1         |           | JUL 15 2019                      |
|       |                                |       |            |          |           |         | Small Fab - 2         |           |                                  |
|       |                                |       |            |          |           |         | Small Fab - 3         |           |                                  |
|       |                                |       |            |          |           |         | Small Fab - 4         |           |                                  |
|       |                                |       |            |          |           |         | Small Fab - 5         |           |                                  |
|       |                                |       |            |          |           |         | Small Fab - 6         |           |                                  |
|       |                                |       |            |          |           |         | Small Fab - 7         |           |                                  |
| 120   | QC 5                           | 2 pcs | 7/12/19    |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>40<br>9-89<br>JUL 15 2019 |
|       |                                |       |            |          |           |         | QC 5 - 12             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 17             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 18             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 19             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 22             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 24             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 3              |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 43             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 49             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 51             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 58             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 68             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 9              |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 50             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 30             |           |                                  |
|       |                                |       |            |          |           |         | QC 5 - 40             |           |                                  |
| 121   | Powdercoat - 1 White GI(A)-B4B | 2 pcs | 7/12/19    |          | 0.00      | 0.15    | Powdercoat - 1 - B4B  |           | Bk 19-9-16.                      |
|       |                                |       |            |          |           |         | Powdercoat - 2 - B4B  |           |                                  |
|       |                                |       |            |          |           |         | Powdercoat - 3 - B4B  |           |                                  |
|       |                                |       |            |          |           |         | Powdercoat - 4 - B4B  |           |                                  |
| 122   | QC 3                           | 2 pcs | 7/12/19    |          | 0.00      | 0.00    | QC 3 - 10             |           |                                  |
|       |                                |       |            |          |           |         | QC 3 - 13             |           |                                  |

12/15/59  
START: 12:40 OUT: 3:00 FINISH: 1:10

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|     |                             |          |         |                     |                           |
|-----|-----------------------------|----------|---------|---------------------|---------------------------|
|     |                             |          |         | QC 3 - 15           |                           |
|     |                             |          |         | QC 3 - 17           |                           |
|     |                             |          |         | QC 3 - 18           |                           |
|     |                             |          |         | QC 3 - 2            |                           |
|     |                             |          |         | QC 3 - 28           |                           |
|     |                             |          |         | QC 3 - 3            |                           |
|     |                             |          |         | QC 3 - 30           |                           |
|     |                             |          |         | QC 3 - 34           |                           |
|     |                             |          |         | QC 3 - 36           |                           |
|     |                             |          |         | QC 3 - 41           |                           |
|     |                             |          |         | QC 3 - 51           |                           |
|     |                             |          |         | QC 3 - 58           |                           |
|     |                             |          |         | QC 3 - 59           |                           |
|     |                             |          |         | QC 3 - 68           |                           |
|     |                             |          |         | QC 3 - 9 <i>DAS</i> |                           |
|     |                             |          |         | QC 3 - 40 <i>81</i> |                           |
|     |                             |          |         | QC 3 - 19 <i>89</i> |                           |
|     |                             |          |         | QC 3 - 43           | <i>JUL 17 2019</i>        |
|     |                             |          |         | QC 3 - 24           |                           |
| 130 | Packaging 3-1 - Stock - B4B | 2<br>pcs | 7/12/19 | 0.00 0.00           | Packaging 3 - 1 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 2 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 3 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 4 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 5 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 6 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 7 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 8 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 9 - B4B     |
|     |                             |          |         |                     | Packaging 3 - 10 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 11 - B4B    |
|     |                             |          |         |                     | Packaging 3 - 12 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 13 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 14 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 15 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 16 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 17 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 18 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 19 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 20 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 21 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 22 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 23 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 24 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 25 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 26 -<br>B4B |
|     |                             |          |         |                     | Packaging 3 - 27 -        |

|                |     |         |           |                        |  |
|----------------|-----|---------|-----------|------------------------|--|
|                |     |         |           | B4B                    |  |
|                |     |         |           | Packaging 3 - 28 - B4B |  |
|                |     |         |           | Packaging 3 - 29 - B4B |  |
|                |     |         |           | Packaging 3 - 30 - B4B |  |
|                |     |         |           | Packaging 3 - 31 - B4B |  |
|                |     |         |           | Packaging 3 - 32 - B4B |  |
|                |     |         |           | Packaging 3 - 33 - B4B |  |
|                |     |         |           | Packaging 3 - 34 - B4B |  |
|                |     |         |           | Packaging 3 - 35 - B4B |  |
|                |     |         |           | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - SA | 2   | 7/12/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                | pcs |         |           | QC 21 - SA - 70        |  |
|                |     |         |           | QC 21 - SA - 53        |  |

Part Op 110 - (Small Fab) ASSEMBLE AS PER DWG

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

121 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: \_\_\_\_\_ OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

122 - (QC3- Inspect Part Finish)

130 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

140 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item   | Component Name | Quantity     | Operation         | Container |
|---------------|----------------|--------------|-------------------|-----------|
| AN3-14A       | Bolt           | 4 Ea (2 ea)  | 110-Small Fab - 1 | 3112900   |
| D4038-11      | Block          | 2 pcs (1 ea) | 110-Small Fab - 1 | 3196590   |
| D4038-3       | Angle, Aft, LH | 2 pcs (1 ea) | 110-Small Fab - 1 | 5027893   |
| D4038-7       | Block          | 2 pcs (1 ea) | 110-Small Fab - 1 | 3196130   |
| MS21042L3     | Nut            | 4 Ea (2 ea)  | 110-Small Fab - 1 | 2149299   |
| NAS1149D0363J | Washer         | 8 Ea (4 ea)  | 110-Small Fab - 1 | 5176545   |

## Job Allocations

| Operation         | Component Part | Required | Inventory | Allocated |
|-------------------|----------------|----------|-----------|-----------|
| 110-Small Fab - 1 | AN3-14A        | 4        | 224       | 0         |
|                   | D4038-11       | 2        | 0         | 0         |
|                   | D4038-3        | 2        | 4         | 0         |
|                   | D4038-7        | 2        | 0         | 0         |
|                   | MS21042L3      | 4        | 1,671     | 0         |
|                   | NAS1149D0363J  | 8        | 1,203     | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                        |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                        |  |



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**Container No: S197989**



**Part: D4038-043**

**Job No: 196418**

**Serial No/Batch: S197989**

**Revision: F**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 07/15/19**